

Date: Thursday, 07/02/2008 11:11:40 AM
User: Linda Lacelle

Process Sheet

SPUT

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : WEARPAD

Job Number : 37292

Estimate Number : 12712

P.O. Number :

This Issue : 07/02/2008 S.O. No. :

Prsht Rev. : NC

First Issue : 11 Type : SMALL/MED FAB

Previous Run : 36714

Part Number : D35371

Drawing Number : D3537 REV C

Project Number : N/A

Drawing Revision : C

Material :

Due Date : 28/02/2008

Qty: 100 Um: Each

Written By :

Checked & Approved By :

Comment : Est Rev. New Issue 07-02-14 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 M304S16GA

304/316 .063 Sheet



Comment: Qty.: 0.1113 sf(s)/Unit Total: 11.1300 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: 106 860

R 8-2-12

2.0 WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: C

Prog Rev: C

R 8-2-12

(129)

2-Deburr if necessary

R 8-2-12

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

05/02/12 (129) SB



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Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

M107051

A/R 2059B Hardcoat

M106834 SP

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

08-03-27

(40X)

7.0

QC10

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-03-27 / 08-03-27

(40)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-03-27 (40)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-1 08-03-29

(40X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-31

(40)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FN-20

08-03-31

(40)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08-04-02

Job Completion



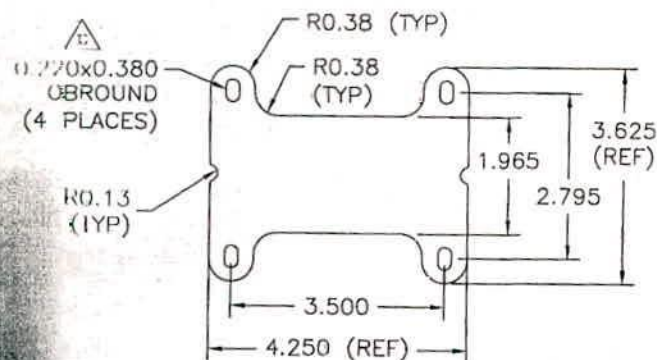
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08-03-31

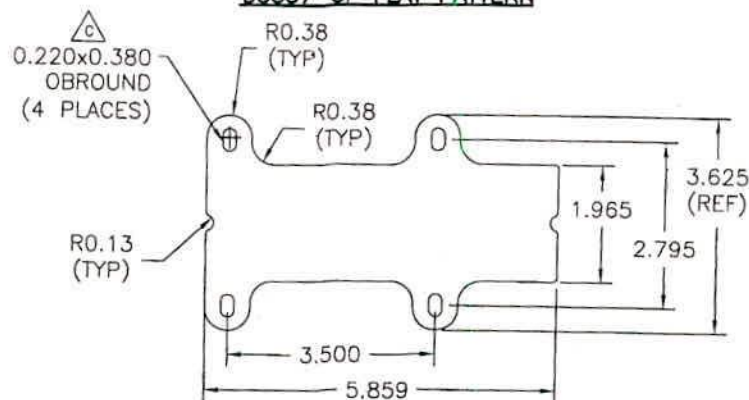
W



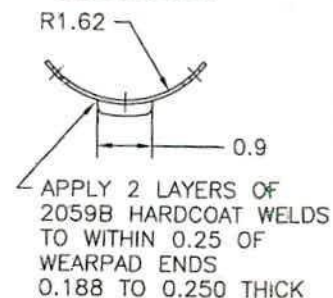
D3537-1F FLAT PATTERN



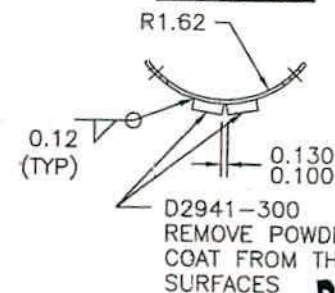
D3537-3F FLAT PATTERN



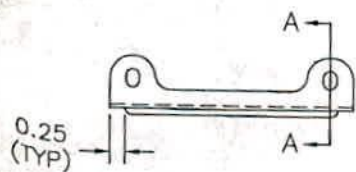
SECTION A-A



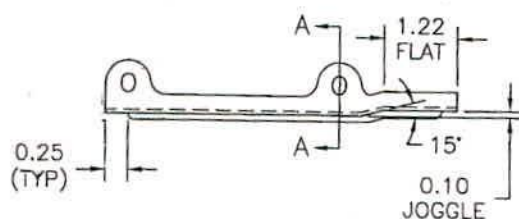
SECTION B-B



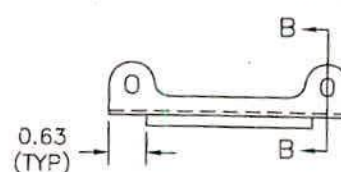
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



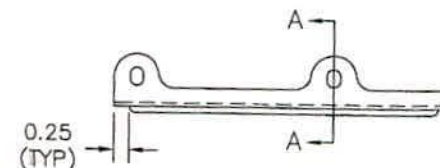
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY
CHECKED	A	APPROVED
DATE	07.04.13	TITLE
		WEARPAD
		DART AEROSPACE USA, INC.
		PORT HADLOCK, MA
		REV. C
		D3537
		SHEET 1 OF 1
		SCALE
		1:2

RELEASED
07.05.09 AM
per ECU
962

